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Item ID: Revision ID: Item Name:	D350-636-0 Skidtube RH	14			Accept	*N900) 040	100)*	Setup	Start Stop	*N *N	S1*
Start Date: Required Date: Reference:	7/10/2012 7/24/2012	Start Qt Req'd Q	•	*1* *1*		Cust Item Customer						;	. 12
Approvals:	Process Pla	an:	D	ate:	Tooling:		Date:			Run	Start	*N	R1*
	QC:		D	ate:	SPC (Y/N):		Date:				Stop	*N	R2*
Sequence ID/ Work Center II)	Operatio Descripti			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
11 0 Skidtubes Skidtubes		Skidtubes	Memo 1- Pick D2600-3	Bent <i>BE</i>	. 0.00 C 12/07/12				•	· · · · · · · · · · · · · · · · · · ·			41 A
	s.		AFT end per dwg	D2750	nove bending marks. Scribe	0E /	467/12					1	
			3- Drill pilot hole deburr.	s for blade fitting	bolt holes using DT8983.		AD 12	07-13	•				
			4- Locate DT8329 fitting	off of blade fitti	ng bolt holes and drill pilot	holes for blade							
			5- Drill only two	fwd step holes usi	ing DT9616. Ensure proper	positioning. <i>SE</i>	4/07/16	3				2	
			6- Drill pilot hole: Jig DT8150 & DT	s as per Dwg D27 18864A for first s	750 sheet 4 (D2750-4 detail ide only DT8864B for seco	s).Drill using drill nd side (detail B)	÷						
			7- Clecko DT886- ***SECOND SID	4B on second side E***	e of tube and drill pilot hole	es for detail B.	\ <aa< td=""><td>) 17-6</td><td>27-13</td><td></td><td></td><td></td><td></td></aa<>) 17-6	27-13				
			fitting location ho	les to 0.500" (tota	V-AW to 0.375" (2 holes part of 4 holes per side) as perd detail T to 0.500" (8 hole	r dwg D2750.		(2					-
			9-Drill pilot holes 0.297".	for wearplates as	per Dwg D2750 using DT	8108 open to							•
			10-Open up holes	of Detail A to 0.2	297" (total of 2 holes per si-	de)							

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Page 3

Item ID: D350-636-014 Accept *N900040100* Setup Start **Revision ID:** Skidtube RH Item Name: **Start Date: Start Qty:** 1.00 7/10/2012 **Cust Item ID: Required Date: 7/24/2012** Req'd Qty: 1.00 **Customer:** Reference: Run Start Process Plan: **Approvals:** Date: Tooling: Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Number Stamp Qty 11-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: M122130 12-Grind welds flush as per Dwg D2750 120 QC10- Inspect visual per QS1004- ground welds *120* QC Memo Quality Control 130 QC5- Inspect part completeness to step on W/O QC Memo Quality Control

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Quality Control

Monday, July 09, 2012 3:49:33 PM Item ID: D350-636-014 Accept *N900040100* Setup Start **Revision ID:** Item Name: Skidtube RH **Start Date:** 7/10/2012 Start Qty: 1.00 **Cust Item ID:** Required Date: 7/24/2012 Req'd Qty: 1.00 **Customer:** Reference: Run **Approvals:** Process Plan: Tooling: Date: Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Operation Tool ID Set Up/ Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 140 Chemical Conversion Coat per QSI005 4.1 0.00 *140* HandFinish 0.00 Memo Hand Finishing 150 QC7-Inspect Chemical Conversion Coat 0.00

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Sequence ID/ Work Center ID 160 *160*)	Operation Description Skidtubes		Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Skidtubes Skidtubes		2-Open holes 3-Open up hoper side) as p 4-Chamfer homographic instructions of the second se	oles of Detail AB and goer dwg D2750. soles of section BE-BE, on sheet 11) d blow out all chips from the as required. D2739 in place as per Capter of the section batch:	round handling to 0.625 " (to BC-BC, AB and ground hann inside of tube. Prepare tube 22/30 p. date: $\sqrt{3} - 3 - \sqrt{4}$ and D2743 as per dwg D275	otal of 8 holes Inding (welding to the for welding).	/18	DL 1.	2/07	/18		
			ground handling holes (t	otal of 4 places per side) as	~	>-	B	(z/07	/23		

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Item ID: D350-636-014 Accept *N900040100* Setup Start **Revision ID:** Skidtube RH Item Name: **Start Date:** Start Qty: 1.00 7/10/2012 **Cust Item ID:** Required Date: 7/24/2012 Req'd Qty: 1.00 **Customer:** Reference: Run Start Process Plan: Approvals: Date: Tooling: Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Reject Reject Accept Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 170 QC10- Inspect visual per QS1004- ground welds *170* OC Memo Quality Control 180 QC5- Inspect part completeness to step on W/O *120* QC 0.00 Memo Quality Control 190 Pressure Wash per QS1005 4.3 0.00 1 76 12-7-25 *190* HandFinish 0.00 Memo Hand Finishing Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

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Monday, July 09, 2012 3:49:33 PM Item ID: D350-636-014 Accept *N900040100* Setup Start **Revision ID:** Skidtube RH Item Name: Start Qty: 1.00 **Start Date:** 7/10/2012 **Cust Item ID:** Required Date: 7/24/2012 **Req'd Qty:** 1.00 **Customer:** Reference: Run **Approvals:** Process Plan: Date: ____ Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. **Work Center ID** Description **Run Hours** Code Otv Qty Number Stamp White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 200 0.00 *200* Powdercoat Powder Coating 210 QC3-Inspect Part Finish 0.00 *210* 1 RH & @ 12/07/25 QC Memo 0.00

Inspect for foreign object per QSI 024

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Approvals:		ın:				ate:		j	Run Sta Sto	171	R1* R2*
Sequence ID/ Work Center II 230)	Operation Description	······································	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230 HandFinish Hand Finishing	, i	2-assemble of A/R 55-o'rin 3-Assemble 4-Inspect Fo 5-Spray insid 6-Install blad SIKA FLEX BATCH: EXP DATE: 7-assemble of A/R 55-o'rin	tube hardware as per or Foreign Objects de of tube with "LPS-3 le fitting D3488-041, 1241 122.30 14	22 and apply o'ring lube 3 4 8 . Iwg D2750 sikaflex batch " batch: N/A wearshoe g D3492 and apply o'ring lube				1 RH	8		12/04
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Item ID: D350-636-014 Accept *N900040100* Setup Start **Revision ID:** Item Name: Skidtube RH **Start Date:** 7/10/2012 Start Qty: 1.00 **Cust Item ID:** Required Date: 7/24/2012 Req'd Qty: 1.00 **Customer:** Reference: Run Start Approvals: Process Plan: Date: Tooling: Date: Stop QC: Date: SPC(Y/N): Date: Sequence ID/ Operation Tool # Plan Set Up/ Tool ID Reject Reject Accept Insp. Work Center ID Description **Run Hours** Code Qty Number Stamp **Qty** 240 QC5- Inspect part completeness to step on W/O *240* QC Memo Quality Control 250 Pick Kit 0.00 *250* Packaging 0.00 Memo Packaging 260 QC4-100% Inspect kits for completeness *260* OC Memo Quality Control

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Item ID: D350-636-014 Accept *N900040100* Setup Start **Revision ID:** Skidtube RH Item Name: Start Qty: 1.00 **Start Date:** 7/10/2012 **Cust Item ID:** Required Date: 7/24/2012 **Reg'd Oty:** 1.00 **Customer:** Reference: Run Process Plan: **Approvals:** Date: **Tooling:** Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Tool # Plan Set Up/ Tool ID Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty Oty Number Stamp 270 0.00 Packaging *270* Packaging 0.00 Memo Packaging Package as per PPP D350-636-014 280 QC21- Final Inspection - Work Order Release 0.00 *280* QC 0.00 Memo Quality Control

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Work Order ID:

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Parent Item:

D350-636-014

Parent Item Name:

Skidtube RH

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:H02.09.25Rearranged procedure stepsKJ IPP Rev:105.12.08Rearranged procedure stepsEC IPP Rev:J06.03.30Per rev. D

EC IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

IPP Rev:M 08-09-23 revF as per dwg DD verified by:ec DD verf:EC IPP Rev:O 10 10 01 as per IIN

IPP Rev:N 10.06.22 revise seq110

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS4-1032-225		Purchased	No			230	Each	2,888.0000		30		· · ·	
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;	Re	esolution:	Dispositio	n: ' Q	A: N/C CI	osed: Date:	
NCR:				ER NON-CONFORMANC			
D.47E		Description of NC		Corrective Action Section B		Verification Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section C. Chief Fng	QC Inspector
							· / / / / / / / / / / / / / / / / / / /

Monday, July 09, 2012 3:49:31 PM

Work Order ID: 87012 Parent Item: D350-636-014 **Start Date:** 7/10/2012 Required Date: 7/24/2012 Parent Item Name: Skidtube RH Start Qty: 1.00 Required Qty: 1.00 D2600-3-BENT Manufactured No 110 Each 33.0000 Extrusion Bent Loc Qty Loc Code LG 33 66875 73253 75021 75022 75023 81330 83305 86330 17 D2739 Manufactured No 160 Each 14.0000 350 l Beam Loc. Qty Loc Code LG 72155 81508 83448 83548 85486 86615 Manufactured No 250 Each 34.0000 Blade, 350 Skidtube Location Loc Qty Loc Code ST -10 ST466 44 71856 83135 33

		- -										
W/O:			WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	_ Date: _						
	R	lesolution:	Disposition		QA: N/C CI	osed:		Date: _				
NCR:		,	WORK ORDE	R NON-CONFORMAN	CE (NCR)						
DATE	STEP	Description of NC	Initial	Corrective Action Section I Action Description	Sign &	Verific			Approvai			
	1	Section A	Chief Eng	Chief Eng	Date	Section	on C	Chief Eng	QC Inspector			
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Monday, July 09, 2012 3:49:31 PM

Work Order ID:	87012										
Parent Item:	D350-636-014							Start l	Date: 7/10/2012	Re	quired Date: 7/24/2012
Parent Item Name:	Skidtube RH							Start	Qty: 1.00		equired Qty: 1.00
D2743 Crossbolt Spacer		Manufactured	No			160	Each	152.0000	8	8	BE12/07/A
		·		Location	<u>1</u>	Loc Qty		Loc Code	STORY OF THE STORY	**	B85459 x1
				LG		78					
Ĭ.					81965	23					
					83262	55					
				LG001		74					
					67766	4					
					68251	3					
					73403	64					
					74445	1					
					79517	2					
D2744 Cap		Manufactured	No			160	Each	60.0000	1	1	BEALOHIA
				Location	<u>1</u>	Loc Qty		Loc Code			/ /
				LG002		60					
					62715	1					
					83412	21		•			
					85506	38					
D2745 Bushing		Manufactured	No			230	Each	258.0000	8	% -	12/07/25
				Location	<u>l</u>	Loc Qty		Loc Code	U		* /
				FP		206					
					79518	6					
					85416	200					
				FP001		52					
					69529	1					
					76142	1			-		
					83260	50					

Duit Au	oopaoc											
W/O:			WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
	:											
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes No DQA: Date:							
	Re	esolution:	Disposition	n: <u>`</u>	QA: N/C Clo	sed:		Date: _	<u>_</u>			
NCR:	:		WORK ORD	ER NON-CONFORMA	NCE (NCR))						
DATE	STEP	Description of NC	Initial	Corrective Action Section Action Description	n B Sign &		cation	Approval	Approval			
		Section A	Chief Eng	Chief Eng	Date	Secti	ion C	Chief Eng	QC Inspector			
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* Monday, July 09, 2012 3:49:32 PM

Work Order ID: 87012 Parent Item: D350-636-014 **Start Date:** 7/10/2012 Required Date: 7/24/2012 Parent Item Name: Skidtube RH Start Qty: 1.00 Required Qty: 1.00 D3488-042 No 230 Manufactured Each 28.0000 Blade Fitting Assembly, RH Location Loc Qty Loc Code FP 83417 11 FP002 29 85734 5 86054 12 D3490-1 160 Manufactured Each 79.0000 Cross Bolt Spacer Location Loc Qty Loc Code LG 68 81976 2 85419 66 LG001 11 62450 74875 77042 3 2 83269 D3490-5 Manufactured No 160 Each 31.0000 Cross Bolt Spacer Location Loc Qty Loc Code LG001 31 83373 31 D3492-1 No 230 Manufactured Each 205.0000 12/07/25 Plug Location Loc Qty Loc Code FP002 198 69531 8 74444 2 76235 4 83259~ 184 FP-A 83098

Monday, July 09, 2012 3:49:32 PM

Shop Packet Print

Page 6

- -	1									
W/O:	T		WO	RK ORDER CHANG	ES					
DATE	STEP	PRO	PROCEDURE CHANGE		B	/	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				•						
Part No	:	PAR #:	Fault Categ	ory:	_ NCR: \	es N	o DQ	A:	Date:	
		esolution: Disposition:								
NCR:			WORK ORDE	R NON-CONFORM	ANCE (N	ICR)				
DATE	STEP	Description of NC			tion B		Verific	cation	Approval	Approval
	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		gn & Date	Secti	on C	Chief Eng	QC Inspector
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		-								
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Picklist Print

Monday, July 09, 2012 3:49:32 PM

Work Order ID:

87012

Parent Item:

D350-636-014

Parent Item Name:

Skidtube RH

Start Date: 7/10/2012

135.0000

32.0000

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

D3492-5		
Plug		

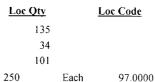
Manufactured	N

Location	1
fpa	
	83100 🗸

83530

Loc	Qt
	1
• • •	1

230



Each



	D3493-1	
S	Washer	

Manufactured

Manufactured

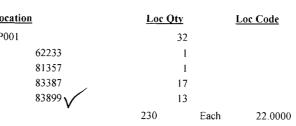
No

Location	Loc Qty		Loc Code
ST050	97		
77573	1		
82023	2		
83097	94		
-	230	Each	22.000

$=$ $2\times$	
1	



<u>Location</u>	Loc Qty	Loc Code
FP001	32	
62233	1	
81357	1	
83387	17	
83899	13	



1 1		12/0	1 7 /25
			

D3536-25
Gasket

									
W/O:			WO	RK ORDER CHANG	iES .				•
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
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	:								
Part No	:	PAR #:	Fault Categ	ory:	_ NCR: Yes	No DQ	A:	Date:	
	Res	solution:	Disposition	QA: N/C C	A: N/C Closed: Date:				
NCR:	ļ.		WORK ORDE	R NON-CONFORM	ANCE (NCF	R)			
DATE	STEP Description of NC Section A		Initial Chief Eng	Corrective Action Sec Action Description Chief Eng	tion B Sign 8 Date	k Sect	cation ion C	Approval Chief Eng	Approval QC Inspector
	i		Office Ering	Cillel Ling	Date				
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Monday, July 09, 2012 3:49:32 PM

Work Order ID:	87012											
Parent Item:	D350-636-014							Start	Date: 7/10/2012	Rear	uired Date: ?	7/24/2012
Parent Item Name:	Skidtube RH								Start Qty: 1.00		Required Qty: 1.00	
D3537-1 Wearpad		Manufactured	No			230	Each	112.0000	3		•	1/25
				Location	<u>on</u>	Loc Qty		Loc Code	_		1	l
				FP002		112						
		•			81362	3				_		
					83254	1				_		
					83255	3						
					83256	20				_		
					85457	37				_		
D2/21 1					85458	48				_		
D3631-1		Manufactured	No			230	Each	283.0000	8	8		
Washer						4-			Q	(2^{\prime})	12	107/25
				Location	<u>on</u>	Loc Qty		Loc Code	a		•	
				FG		268						
_					81874	2				****		
~-					83588	266				_		
				ST072		15				_		
					68062	2				_		
					75548	13				_		
D3791-1		Manufactured	~ No			230	Each	26.0000	1	- In		
Wearplate		······································					20011	20.0000	. ,	(d)	12/	07/25
				Locatio					· · · · · · · · · · · · · · · · · · ·	ح	· · · · · · · · · · · · · · · · · · ·	03/-23
					<u>)n</u>	Loc Qty		Loc Code				
				FP002		26				_		
					62239	2				_		
					83392	12				_		
D3793-1					83902	12				_		
		Manufactured	No			230	Each	26.0000	1	128	10/	01
Wearshoe									·		12/	07/25
				Locatio	<u>on</u>	Loc Qty		Loc Code			,	
				FP001		26						
					82171	2				_		
	7				83393	11		water.	~	_		
					83903	13				_		

W/O:		WORK ORDER CHANGES												
DATE	STEP	PR	OCEDURE CHA	NGE	By Date Qty Approval Chief Eng / Prod Mgr					Approval QC Inspector				
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Part No.		PAR #:	Foult Coto	aconii.	NCE	Pi Voc. N	lo DO	A.	Dotos	. ,				
1		esolution:												
NCR:				ER NON-CONFORM										
DATE				- 1.44.1	ction B		1			<u> </u>				
	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	1	Sign & Date	- Verific Secti	cation on C		Approval QC Inspector				
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Work Order ID:	87012										
Parent Item:	D350-636-014							Start	Date: 7/10/2012	Requi	red Date: 7/24/2012
Parent Item Name:	Skidtube RH								Qty: 1.00		iired Qty: 1.00
D3793-3 Wearshoe		Manufactured	No			230	Each		l	1 	12/07/25
				Locatio	<u>ın</u>	Loc Qty	•	Loc Code			, ,
				FP001		2	8				
					83394		6				
D					83901		2				
D3794-1		Manufactured	No			230	Each	24.0000	1	1	, , , _
Gasket										(\mathcal{P})	12/07/25
				Locatio	n	Loc Qty		Loc Code	i.		
				FP			4				
					82167	•	4				
				FP002		2	0				
					83395	2	0			· 	
D3794-3		Manufactured	No			230	Each	45.0000	1	L	1-1-1-
Gasket									t in the part	(P)	12/07/25
				Locatio	<u>n</u>	Loc Oty		Loc Code	,		, (
				FP		1	9				
					83396	1	9				
				FP002		2	6				
					74530		2				
					86243	2	4				
MS21043-6		Purchased	No			230	Each	586.0000	4	4	
NUT									·	. (D)	12/07/25_
				Locatio	<u>n</u>	Loc Qty		Loc Code	•		' [[
				FG		2	С				
					103693	2	C				
				ST301		56	5			=	
					117887		2				
					118384	6					
					120308	50)				

W/O:			WO	RK ORDER CHANG	GES					*,
DATE	STEP	PRO	OCEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	1									
Part No	·	PAR #:	Fault Categ	jory:	NCI	R: Yes	No DQ	A:	Date: _	
	Re	esolution:	Disposition: QA: N/C Closed:						Date: _	
NCR:	-		WORK ORDE	R NON-CONFORM	ANCE	(NCR)			
DATE	STEP	Description of NC	Corrective Action Sec				Verific	cation	Approval	Approval
DAIL	JILF	Section A	Initial Action Descri Chief Eng Chief Eng		ion Sign & Date		Section C		Chief Eng	QC Inspector
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Monday, July 09, 2012 3:49:32 PM

Work Order ID:	87012							
Parent Item:	D350-636-014						Start Date: 7/10/2012	Required Date: 7/24/2012
Parent Item Name:	Skidtube RH						Start Qty: 1.00	Required Qty: 1.00
MS21083C8 NUT	•	Purchased	No		230	Each 94	.0000 1	D 12/07/25
			<u>Loca</u>	tion	Loc Qty	Loc Co	<u>ode</u>	- ,
			304	,	39			
				121185	22			
				121349	17			•
			FP00	2	1			_
				115884	j		·	_
			ST30		4			_
				115884	0			_
				118077	1			_
				119309	2			_
				119638	1			_
			ST32	1	50			_
P. Comments	· ·			122141	50			
MS21083C8 NUT		Purchased	No		250	Each 94.	0000 2	712-7-26 G
			<u>Loca</u>	<u>tion</u>	Loc Qty	Loc Co	<u>de</u>	Part Osi as from Oat Kenney, as
	`		304		39			
				121185	22			-
				121349	17			_
			FP00:	2	1			-
				115884	1			-
			ST30:	3	4			_
				115884	0			_
				118077	1			_
				119309	2			_
				119638	1			_
			ST32	1	50			_
				122141	50		$\overline{}$	-

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W/O:			WO	RK ORDER CHANGI	ES	<u> </u>			•
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
									
									
Part No	•	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A :	_ Date: _	-
	Resolution:		Disposition): <u>`</u>	_ QA: N/C C	losed:		Date: _	
NCR:		,	WORK ORDE	ER NON-CONFORMA	NCE (NC	₹)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date	& Section		Chief Eng	QC inspector
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Work Order ID: Parent Item:	87012 D350-636-014						Staut 1	Date: 7/10/2012	Page 1 Page 7/24/2012
Parent Item Name:	Skidtube RH							Qty: 1.00	Required Date: 7/24/2012 Required Qty: 1.00
NAS1149C0832R WASHER		Purchased	No		230	Each	250.0000	1	12/07/25
				Location	Loc Qty		Loc Code		(Salt Salt
				ST297	250 250			<u> </u>	
NAS1149D0863J WASHER		Purchased	No		250	Each	221.0000	2	2 0
Ò				Location	Loc Oty		Loc Code		01
				ST298	221				
				118078	34				-
			•	119307	1			- 	-
				120308 121556	86 100			_	-
NAS1515H3L WASHER		Purchased	No	121000	230	Each	311.0000	4	(ap) 12/07/2
				Location	Loc Qty		Loc Code		
				FG	40				
			•.	102472	40				-
			. ,	ST277	271				-
				118686	3				_
				120360	11				-
				121556	57			-	
NAS1611-005		Purchased	No	122151	200 230	Cl.	140,0000	-	
O-RING		Purchased	140			Each	140.0000	8 	12/07/25
				<u>Location</u>	Loc Oty		Loc Code		
				FP001	140				-
				106099	18				
				114220 - 119438	46				
				121415	36 40				
				.2	40				

	1								
W/O:			WC	ORK ORDER CHANGE	ES				•
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
Part No		PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
	R	esolution:	Disposition	n: <u>'</u>	QA: N/C	Closed:		Date: _	
NCR:	:		WORK ORD	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section B			cation	Approval	Approval
	O.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat		ion C	Chief Eng	QC Inspector
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Monday, July 09, 2012 3:49:33 PM

Work Order ID:

87012

Parent Item:

D350-636-014

Parent Item Name:

Skidtube RH

Start Date: 7/10/2012

Required Date: 7/24/2012

Page 12

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010 O-RING	Purchased	No	230 Each	416.0000	8 8 0D 12/07/25
	•	<u>Location</u>	Loc Qty	Loc Code	, ,
		FP001	416		

110915 14 117460 8 118077 118612 3 119438 47 121259 2 121584 2 39 121723 122151:/ 300

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W/O:			WC	RK ORDER CHANG	ES				• • •
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	_ Date: _	
Resolution:			Disposition	n: <u>'</u>	_ QA: N/C	Closed:		Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC	Corrective Action Section B			Verifi	cation	Approval	Approval
	0.2	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat		ion C	Chief Eng	QC Inspector
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	X	T			D2750-041	350 SKIDTUBE ASSEMBLY, LH
		Х			D2750-042	350 SKIDTUBE ASSEMBLY, RH
			X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
				X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
	1	1	1	1	D2739	WEB
	8	8	8	8	D2743	SPACER
	1	1	1	1	D2744	CAP
	8	8	8	8	D2745	BUSHING
	1				D2750-1	SKIDTUBE WELDMENT, LH
		1			D2750-2	SKIDTUBE WELDMENT, RH
			1		D2750-3	SKIDTUBE WELDMENT, LH
			<u> </u>	1	D2750-4	SKIDTUBE WELDMENT, RH
	1	_	1		D3488-041	BLADE FITTING, LH
	<u> </u>	1		1	D3488-042	BLADE FITTING, RH
	4	4	4	4	D3490-1	SPACER
	4	4			D3490-3	SPACER
		-	4	4	D3490-5	SPACER
	8	8	8	8	D3492-041	PLUG ASSEMBLY
	8	8	-		D3492-041	PLUG ASSEMBLY
		<u> </u>	- 8	8	D3492-045	PLUG ASSEMBLY
	1	1	1	1	D3535-25	WEARSHOE
	1	1	1	1	D3536-25	GASKET
Æ	3	3	3	3	D3536-23	WEARPAD
<u> </u>	8	8	8	8	D3631-1	WASHER
_	1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	1		
;	1		_	_	D3793-1	WEARSHOE
A		1	1	1	D3793-3	WEARSHOE
	1	1	1	1	D3794-1	GASKET
L	1	1	1	1	D3794-3	GASKET
<u>F</u>	38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
ZF3	34	34	34	34	AN3C5A	BOLT
_	4	4	4	4	AN3C6A	BOLT
	4	4	4	4	AN6C44A	BOLT
	1	1	1	1	AN8C35A	BOLT
, –	38	38	38	38	AN960C10L	WASHER
/F\—	1	1	1	1	AN960C10L AN960C816L	WASHER
L	4	4	4	4	MS21043-6	NUT
	1	1	1	1	MS21043-5 MS21083C8	NUT
				<u> </u>	NAS1515H3L	WASHER
	4	4	4	4	JIMAO IO IOMOL	VVAORER

QTY QTY QTY QTY PART NUMBER

A REV.	CHANGE MS24694-S293 TO AN8-16A NEW ISSUE DESCRIPTION	CP DS BY	98.09.01 98.04.16 DATE
	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
l R		_	
С	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEC 9133/9157	PH	06.01.05
Е	CHANGE TO STAINLESS STEEL WEARPLATES: ADD RUBBER GASKETS. CHANGE INSERTS: ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515HBL; REMOVE D2741, QTY (2) AMS60C816; REMOVE QTY (2) MS21083C8	СВ	07.05.17
F	INCORPORATE DSI 9413: OTY (3) 03597-1 WAS OTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3536-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3794-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL), WEARSHOE HARDWARE OTY UPDATED (ZN B8-1); D3488-D417-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON. REF. NCR 08-043);	РН	08.07.16

DESIGN	20 ,	DART AEROSPACE USA, I	NC.
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	خانا	DRAWING NO.	REV. F
MFG. APPR.	MO	D2750 s _H	EET 1 OF 11
APPROVED	IM	TITLE	SCALE
DE APPR.	7	350 SKIDTUBE ASSEMBLY	NTS
DATE 08.0	7.16	COPYRIGHT © 1998 BY DART AEROSPACE USA THIS DOCUMENT IS FRINKE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS OF MICE OF COMPANY OF	HORION THAT I'S

GENERAL NOTES:

MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).

DESCRIPTION

MATERIAL: MAKE D2750-11-21-31-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).

FINISH:

ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).

TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: N/A
IDENTIFICATION: N/A
WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
WELD PER DART QSI 004
INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM VIELD TENSILE STRENGTH = 35 KSI
SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL

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В D2750-041 350 SKIDTUBE ASSEMBLY, LH D2750-042 350 SKIDTUBE ASSEMBLY, RH DART AEROSPACE USA, INC. PORT HADLOCK, WA DESIGN DRAWN DRAWING NO. D2750 CHECKED REV. F MFG. APPR. SHEET 2 OF 11 APPROVED SCALE 350 SKIDTUBE ASSEMBLY

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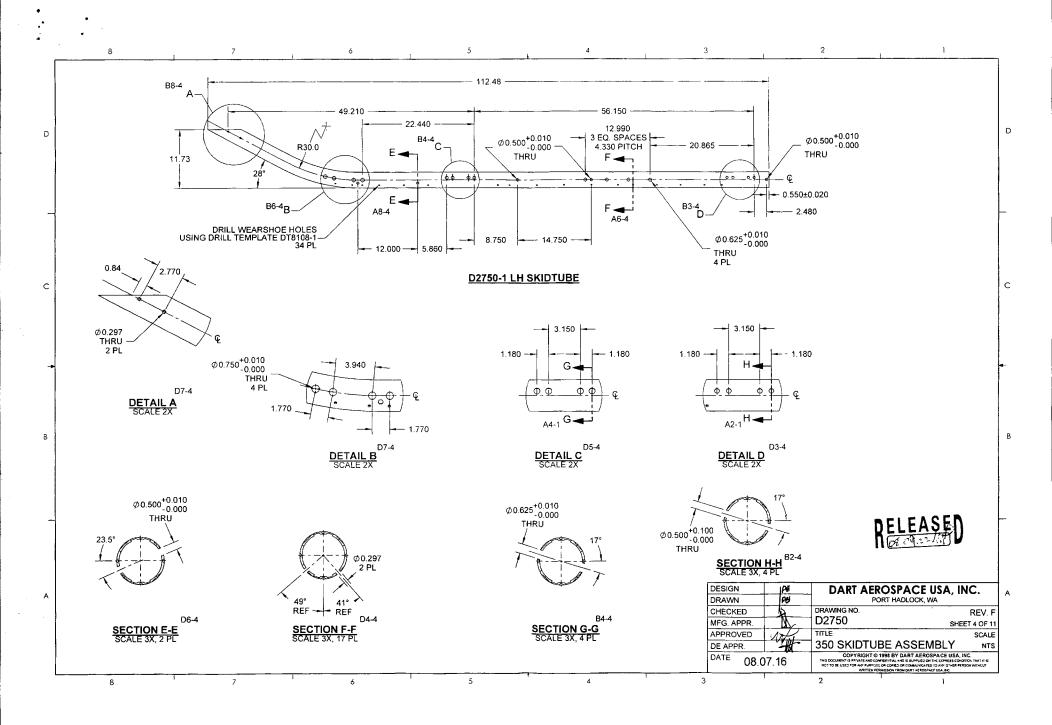
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PORT HADLOCK, WA DESIGN DRAWN DRAWING NO. CHECKED REV. F D2750 MFG. APPR. SHEET 3 OF 11 APPROVED SCALE 350 SKIDTUBE ASSEMBLY

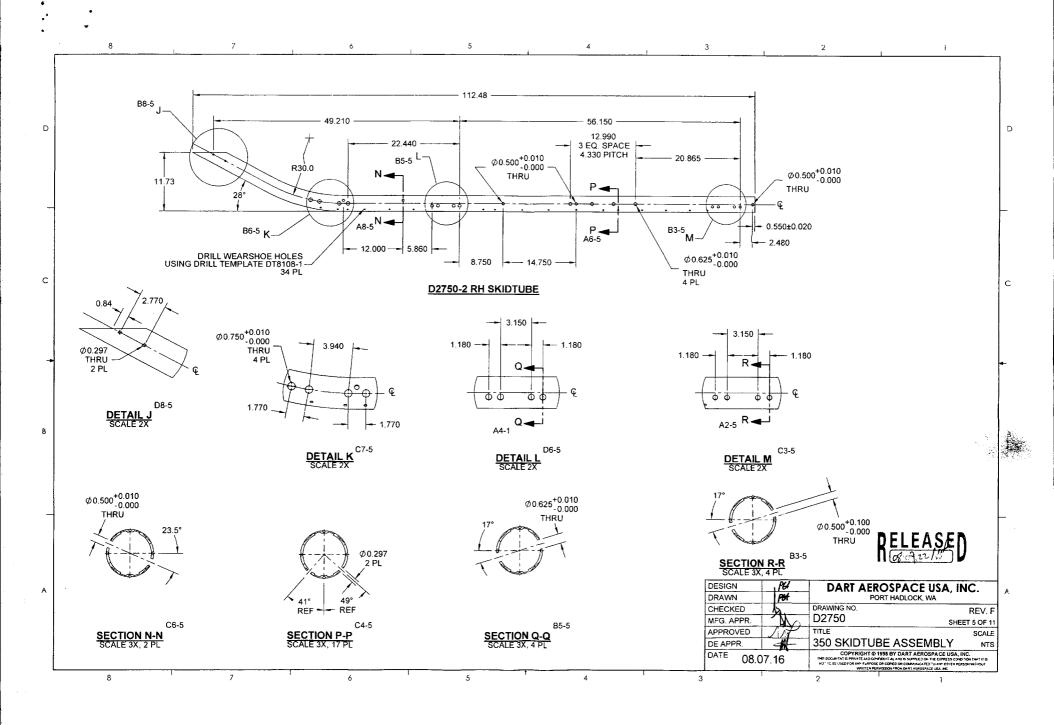
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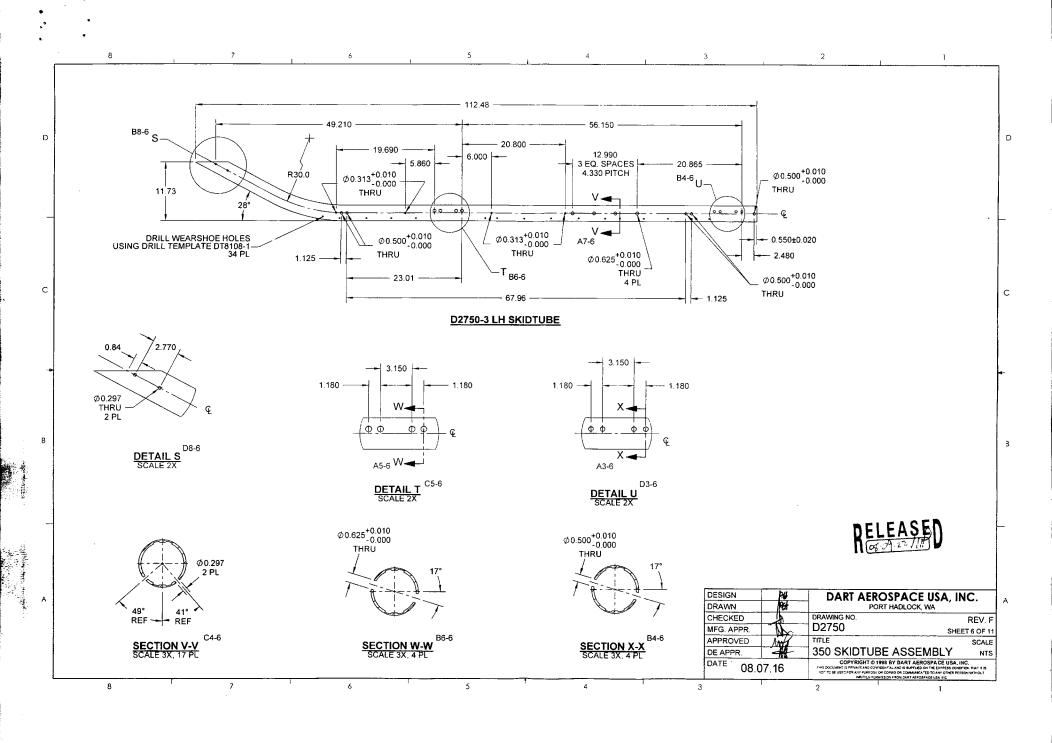


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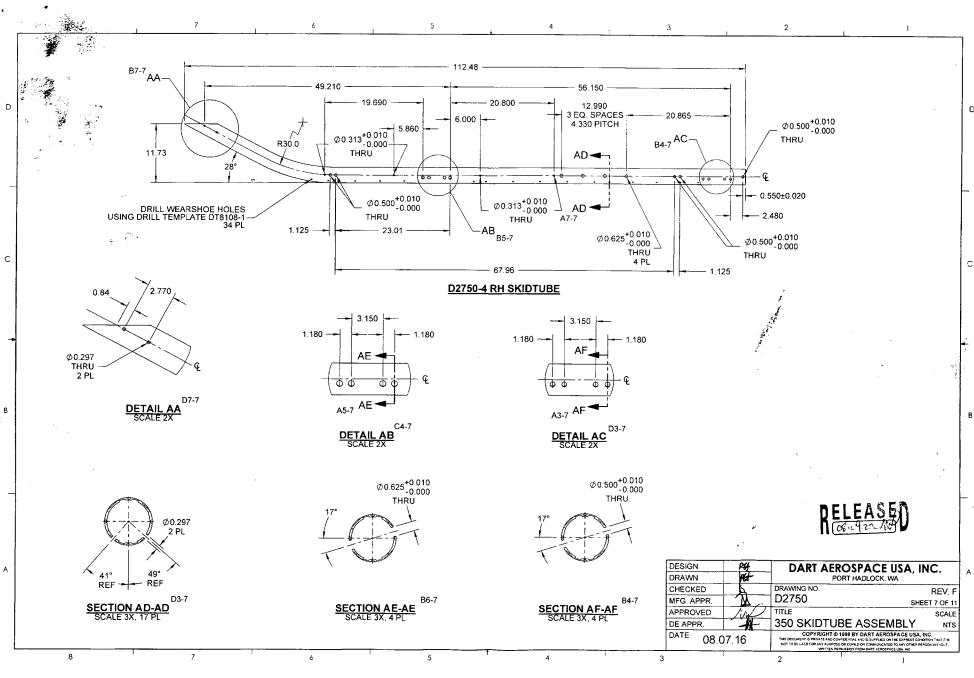
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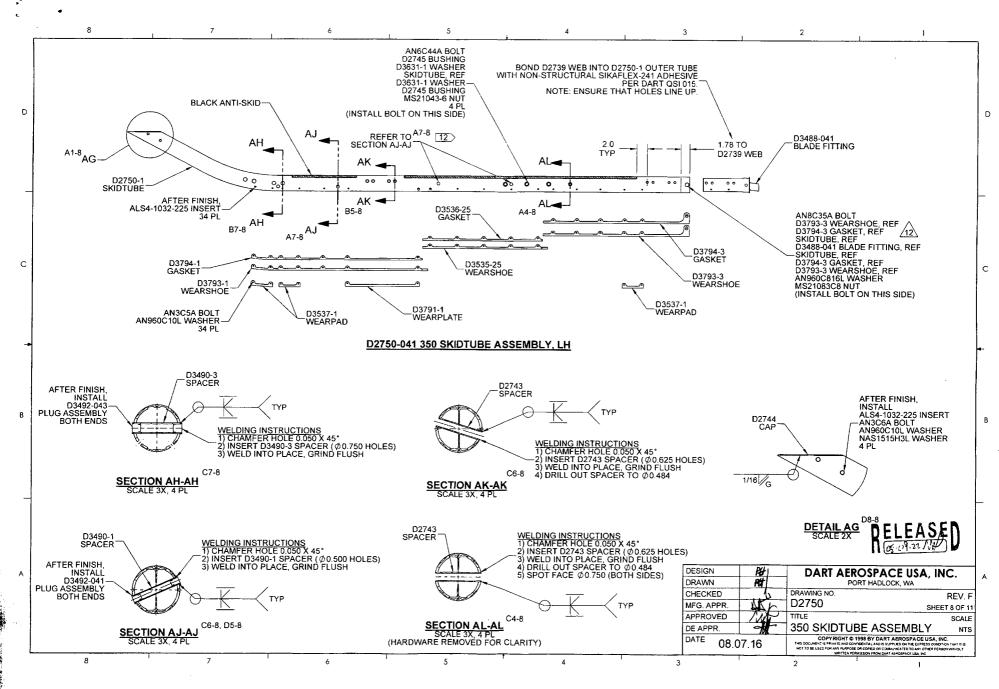
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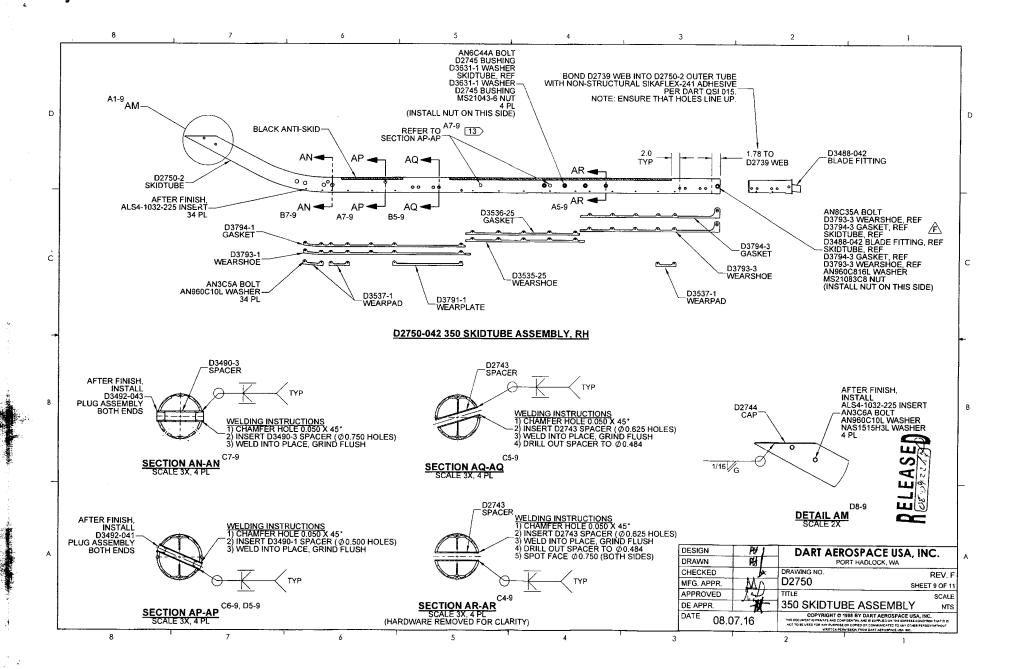
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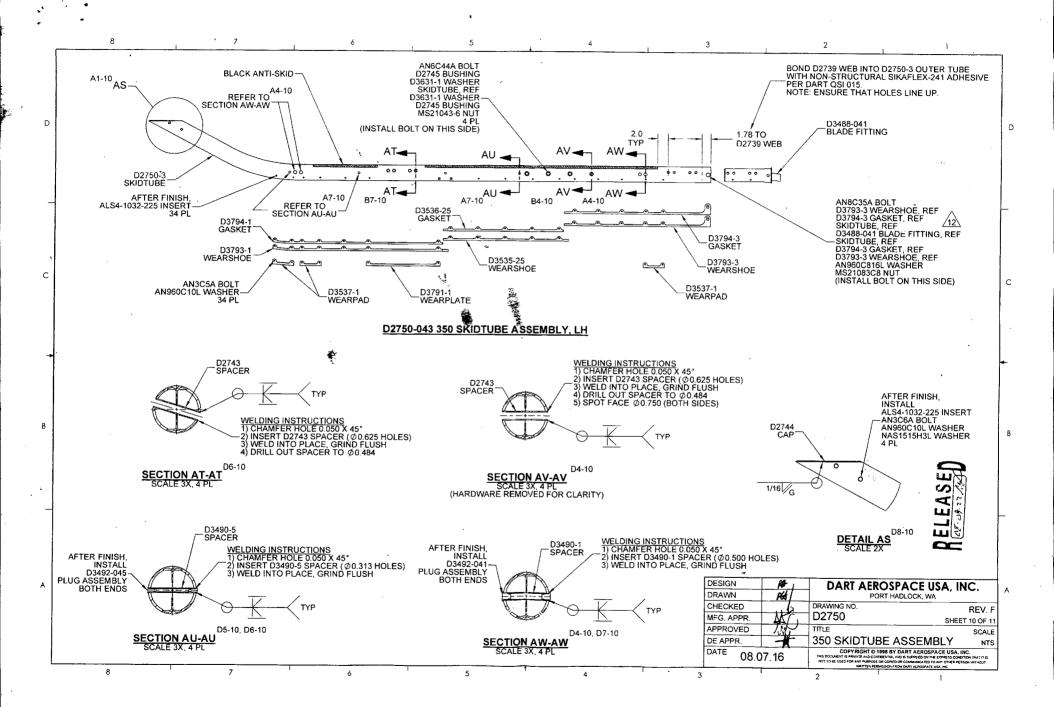
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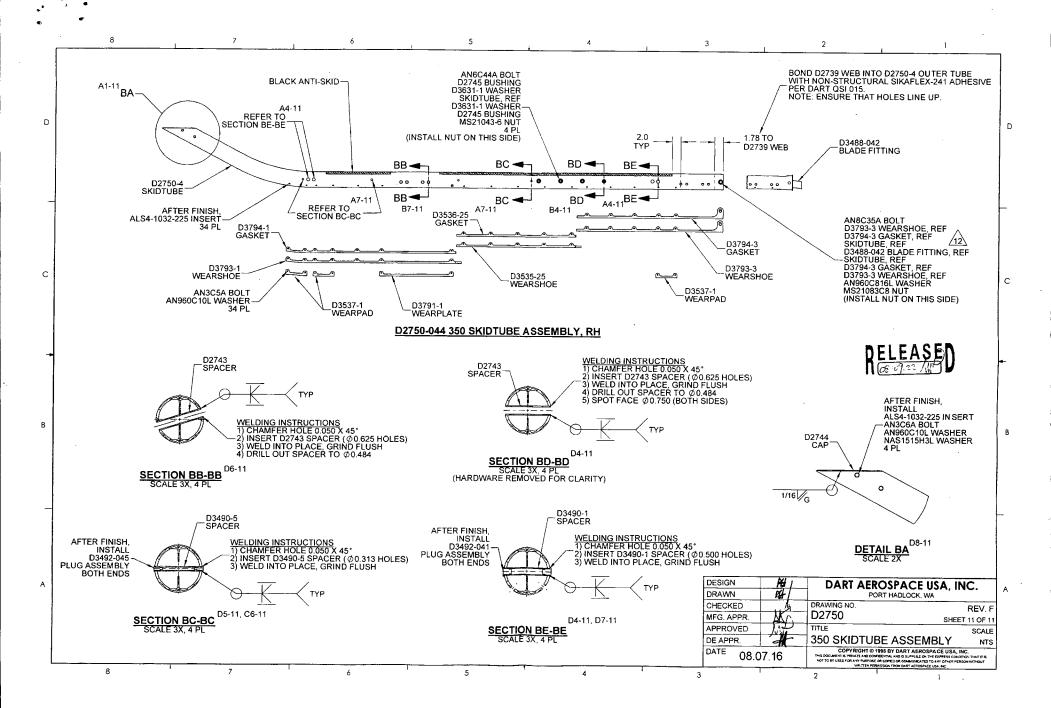
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NOTE: Date & initial all entries



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NO. 298

AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: Burley Elliott	
Job #: 87012 1	
Part#: <u>1350-636-014</u>	
Description: Skid tulsa	·
Welding Process: Tig[Mig[]	•
Base materiel:	
Current: AC[\rightarrow DC[]	

TEST REQUIREMENTS AND RESULTS

Visual:	pass[/	fail[]
Incomplete Penetration:	pass[]	fail[]
Incomplete Fusion:	pass[/	fail[]
Cracks:	pass[]	fail[]
Overlap (cold lap)	pass[]	fail[]
Undercut:	pass[-]	fail[]
Pin holes:	pass[]	fail[]
Porosity (surface):	pass[🚽	fail[]
Coloration:	pass[]	fail[]
Burn through:	pass[-]	fail[]

Qualifier Date of Test Coupon 2.57.23

Welder Dorclay Short Date of Test Coupon 12-07-23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld